

82688

Page 1

Accept

N900040100

```
Setup  Start  *NS1*
      Stop   *NS2*
```

Start Date: 04/04/2012 Start Qty: ~~3.00~~ 4 *3*

Required Date: 18/04/2012 Req'd Qty: 6.00 *3*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82688

April-04-12 1:59:10 PM

82688

Page 2

Item ID: D3183-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 04/04/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 18/04/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble D3183-043 as per Dwg D3183.								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

ent 12/05/08

10

10x

12/05/08

5/2/08

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82688

Page 3

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

[illegible]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 1:59:14 PM

Page 1

Work Order ID: 82688

82688

Parent Item: D3183-043

D3183-043

Parent Item Name: Bracket Assembly

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-045 *D3183-045* Bearing Assembly		Manufactured	No			100	Each	102.0000	2	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST236		102							
				77830		3							
				80903		99							
D3121-21 *D3121-21* Bolt		Manufactured	No			140	Each	4.0000	2	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235		4							
				66969		1							
				74546		3							
M174B1.500X02.250 *M174B1 500X02 250* 17-4 SS Bar 1.50 X2.250		Purchased	No			140	f	28.7479	0.4583	1.447263			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT031		28.7479							
				108309		1.08							
				113568		11.8333							
				115806		3.0846							
				121026		12.75							

Handwritten: B 82/05/08

Handwritten: B 80903 (200)

Handwritten: B 82/05/08

Handwritten: B 82/02/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82688
Description: Bracket		Part Number:	D3183-3
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.188	✓		Rad Gauge SLOS	Gauge Vern
R0.063	+/-0.010	R.0625	✓			
0.182	+/-0.010	0.188	✓			
0.070	+/-0.010	0.072	✓			
0.100	+/-0.010	0.096	✓			
Ø0.201 x 0.100	+/-0.010	0.198 x .103	✓			
0.182	+/-0.010	0.188	✓			
5.32	+/-0.030	5.323	✓			
5.036	+/-0.010	5.0335	✓			
2.120	+/-0.010	2.118	✓			
1.290	+/-0.010	1.290	✓			
0.365	+/-0.010	0.366	✓			
0.218	+/-0.010	0.214	✓			
1.030	+/-0.010	1.032	✓			
1.90	+/-0.030	1.888	✓			
1.012	+/-0.010	1.005	✓		SLOS Rad gauge SLOS Rad Gauge SLOS	Mic Gauge Vern
Ø0.201 x 0.100	+/-0.010	0.195 x .103	✓			
0.786	+/-0.010	0.781	✓			
Ø0.392	+0.002/-0.000	Ø 0.393	✓			
R0.19	+/-0.030	R.188	✓			
3.954	+/-0.010	3.953	✓			
0.162	+/-0.010	0.167	✓			
R0.19	+/-0.030	R.188	✓			
R0.25	+/-0.030	R.250	✓			
4.26	+/-0.030	4.263	✓			
2.080	+/-0.030	2.080	✓			
1.155	+/-0.010	1.158	✓			
0.162	+/-0.010	0.159	✓			
0.36	+/-0.030	0.355	✓			
0.615	+/-0.010	0.612	✓			
0.435	+/-0.010	0.430	✓			
0.200	+/-0.010	0.201	✓			
0.381	+/-0.010	0.380	✓			
0.032	+/-0.010	0.032	✓			

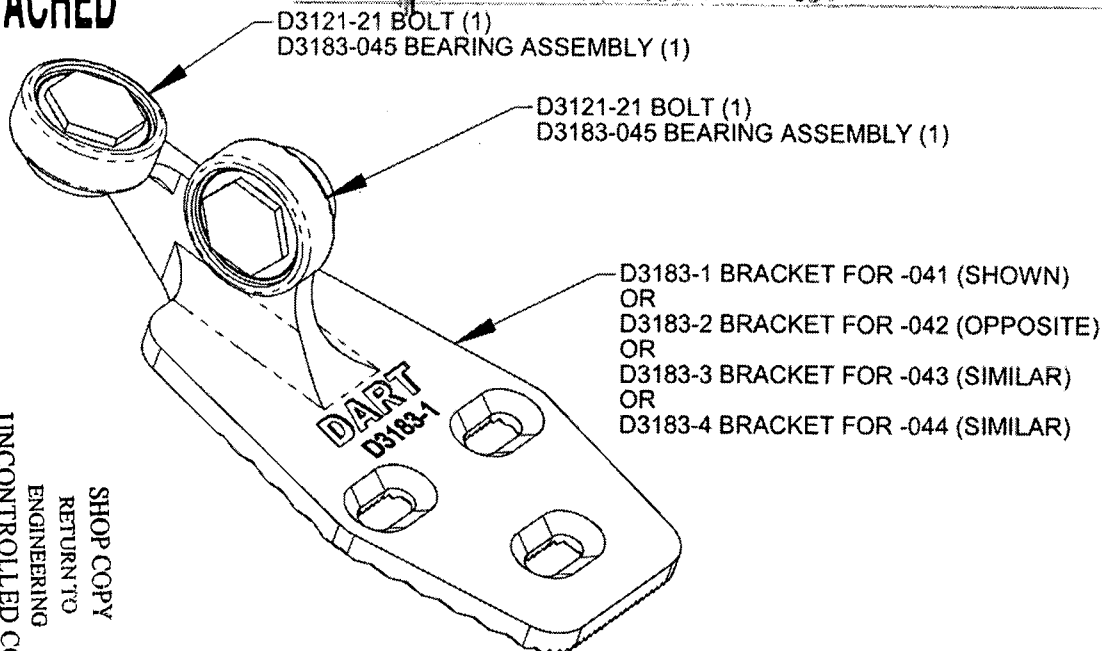
Measured by: <i>SA</i>	Audited by: <i>one</i>	Prototype Approval:	N/A
Date: 12/05/06	Date: 12/05/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-043	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	06.03.09	Dwg Rev update	KJ/JLM	
D	08.01.28	0.182 dimension removed	KJEC/DD <i>SA</i>	<i>DA</i>

DART

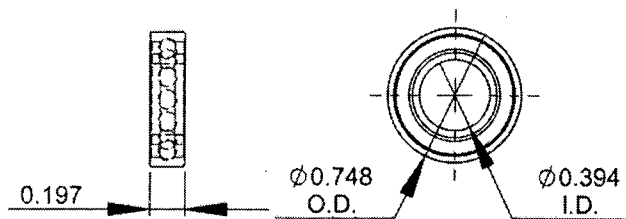
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CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01
DEO ATTACHED



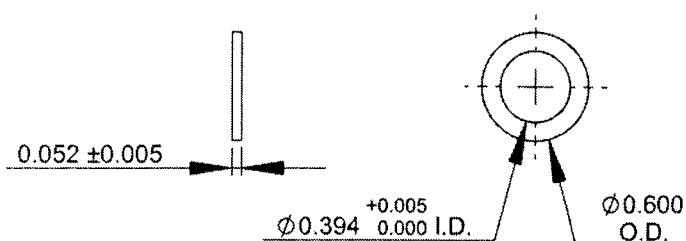
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82688-105
12/04/05

D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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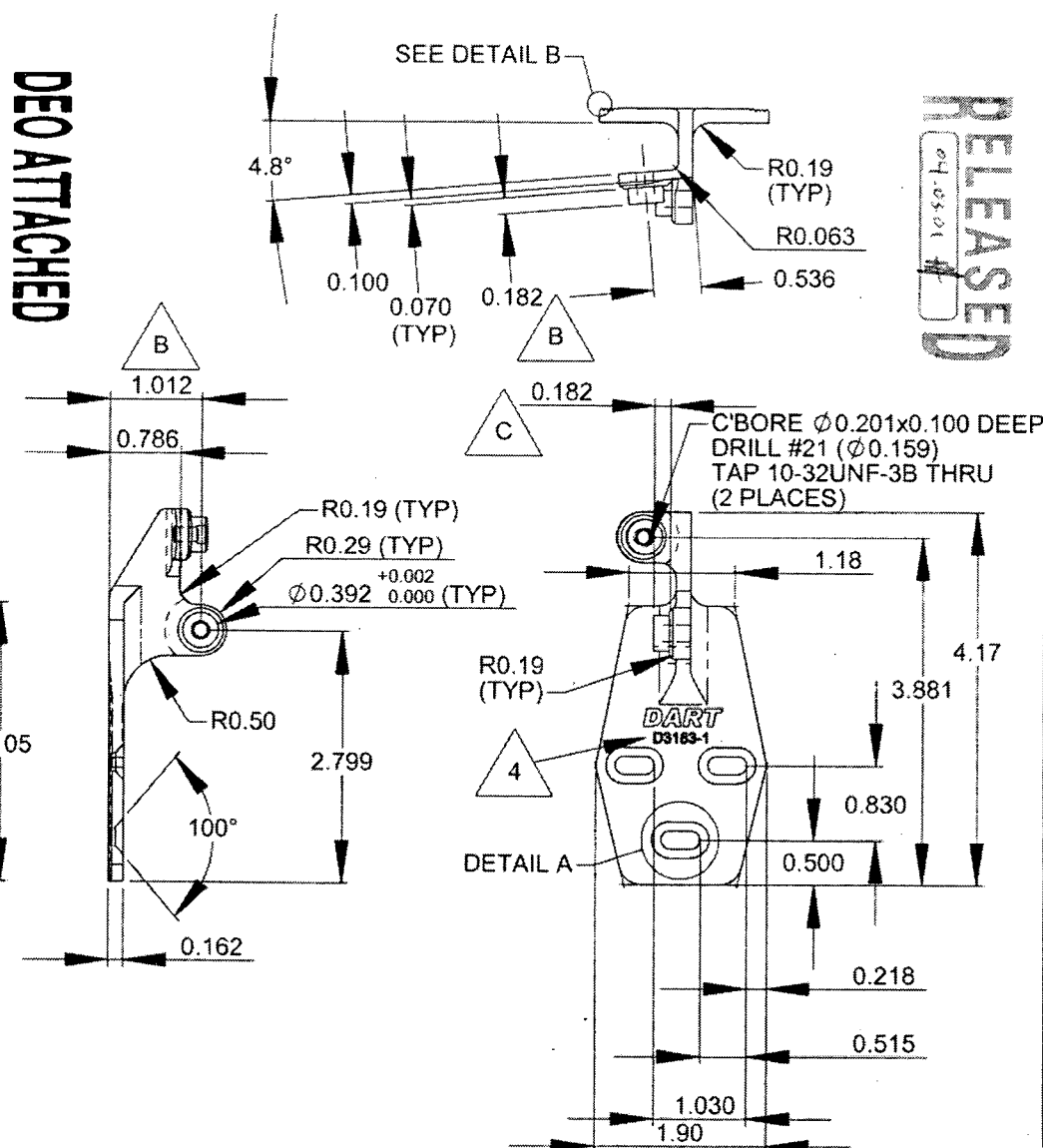
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DART

QA COPY
3095

DESIGN	DRAWN BY	DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C
DATE		TITLE BRACKET ASSEMBLY	SHEET 2 OF 4 SCALE 1:2

04-0501 #



DEO ATTACHED

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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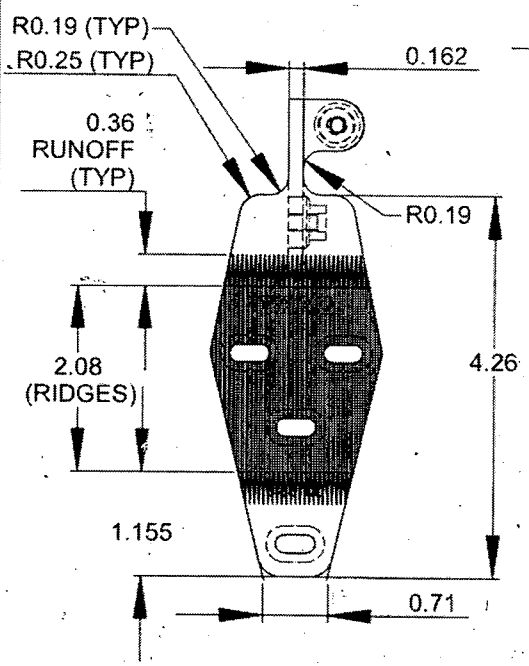
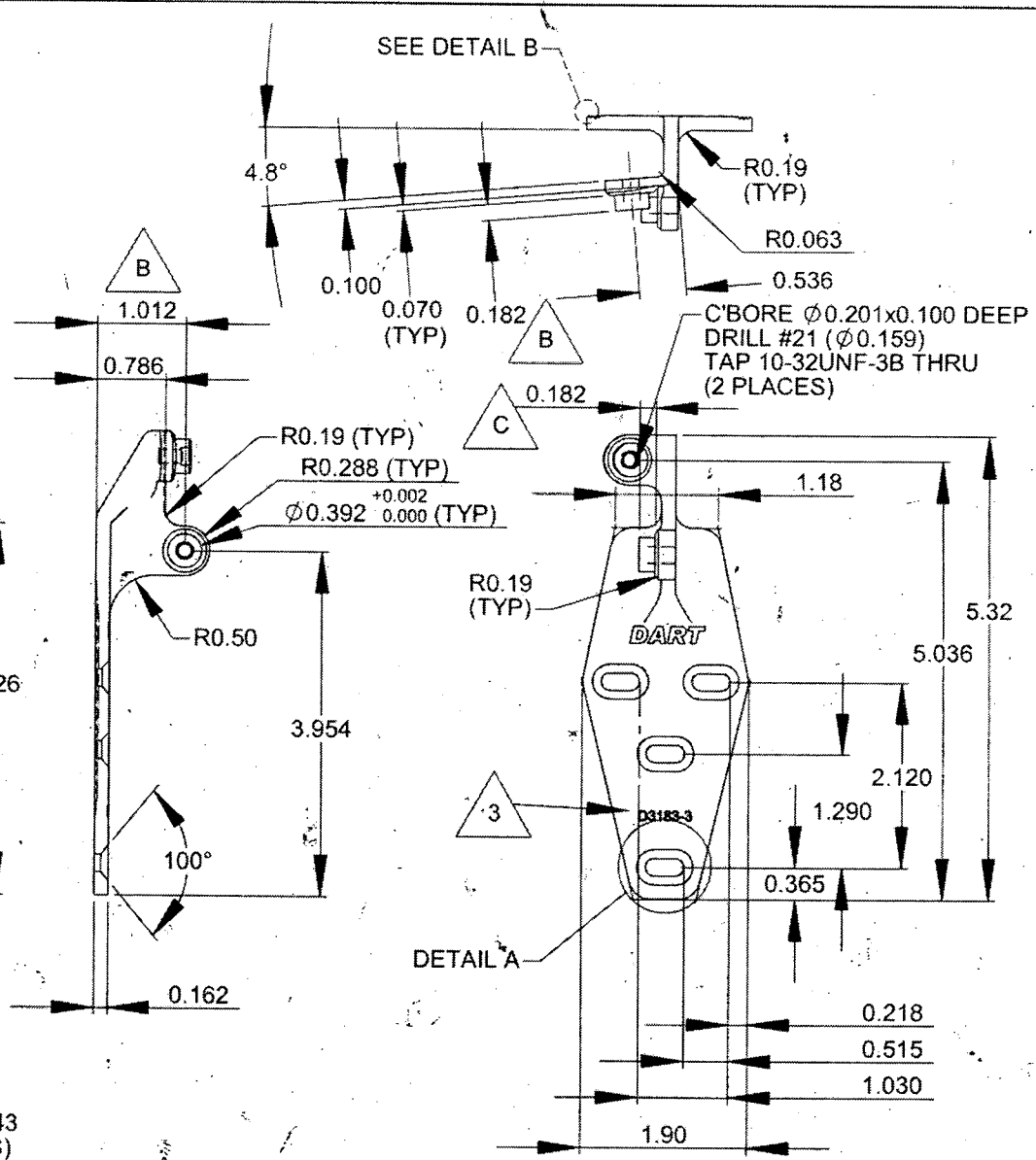
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
	TITLE	SCALE
	BRACKET ASSEMBLY	1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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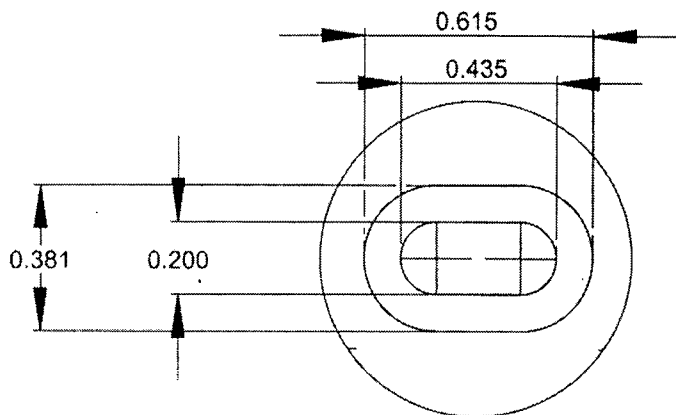
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24-03-01

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DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

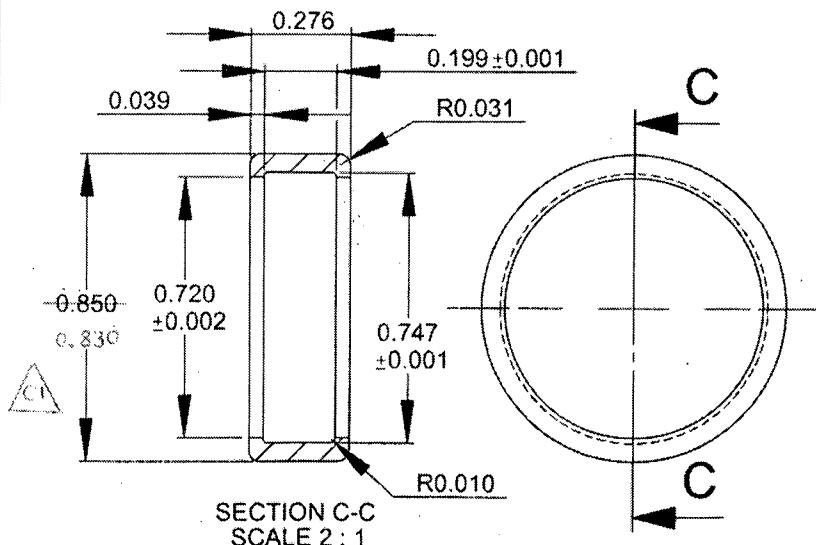
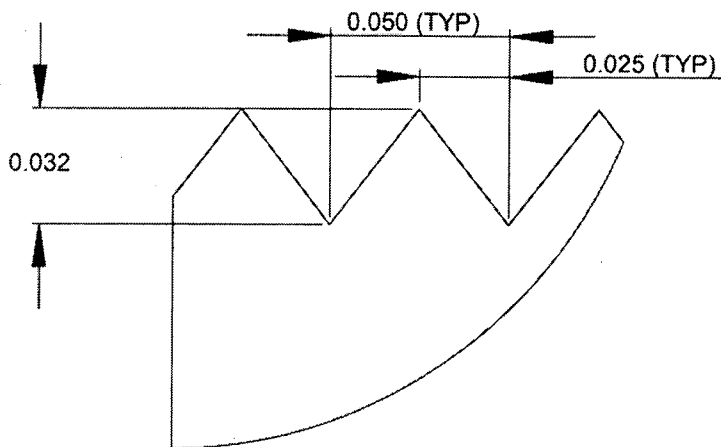


DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED

DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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02688

02688

DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 92	CHECKED J	MFG. APPR. AA	APPROVED MP		DE APPR. H		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
MP

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